










Date: Tuesday, 07/04/2009 10:20:56 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOOR PROCTOR AFT RH
<b>Job Number</b> : 46978	
<b>Estimate Number</b> : 11235	
<b>P.O. Number</b> :	<b>Part Number</b> : D32814
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3281 REV. D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 44337	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/04/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JULIE DAWSON</u>	
<b>Comment</b> : : Est Rev:A 04.07.01 New issue KJ/JLM : Est Rev B 07.08.07 Thermoform in house DL : Ext. Rev C. 08.02.06 to reflect updated Dwg. DL : Est. Rev D. 08.04.15 Material Change DL	
<b>Additional Product</b>	
Job Number: 	
<b>Seq. #:</b>	<b>Machine Or Operation:</b>
<b>Description :</b>	
1.0	MLEXS093F600602
	GE PLASTICS LEXAN SHEET
	 
<b>Comment:</b> Qty.: 4.3330 sf(s)/Unit Total : 25.9980 sf(s) GE PLASTICS LEXAN SHEET	
Material Batch Number <u>M110877</u>	
2.0	HAND FINISH TH
	HAND FINISHING THERMOFORMING
	 
<b>Comment:</b> HAND FINISHING THERMOFORMING	
1) Cut Blanks <u>BB</u> 09/04/20 <u>X6</u>	
3.0	THERMOFORMING
	THERMOFORMING MACHINE
	 
<b>Comment:</b> THERMOFORMING MACHINE	
Thermoform as per Dwg. D32811 and Folio FTA 010	
Dwg. Rev. <u>B</u>	
Folio Rev. <u>B</u> <u>BB</u> 09/04/21 <u>X6</u>	
4.0	QC2
	INSPECT PARTS AS THEY COME OFF MACHINE
	 
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>BB</u> 09/04/21 <u>X6</u>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:20:56 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT RH

Job Number: 46978

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/22 (X6)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/22 (X6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/22 (X6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PPP- 46816

SS 09/04/22 (X6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/23 JA

Job Completion



U 09.04.23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Floor Protector, Aft RH		<b>Part Number:</b>	D3281-4
<b>Inspection Dwg:</b> D3281 <b>Rev:</b> D		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> BB	<b>Date:</b> 09/04/22
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#### TRIMMING SECTION

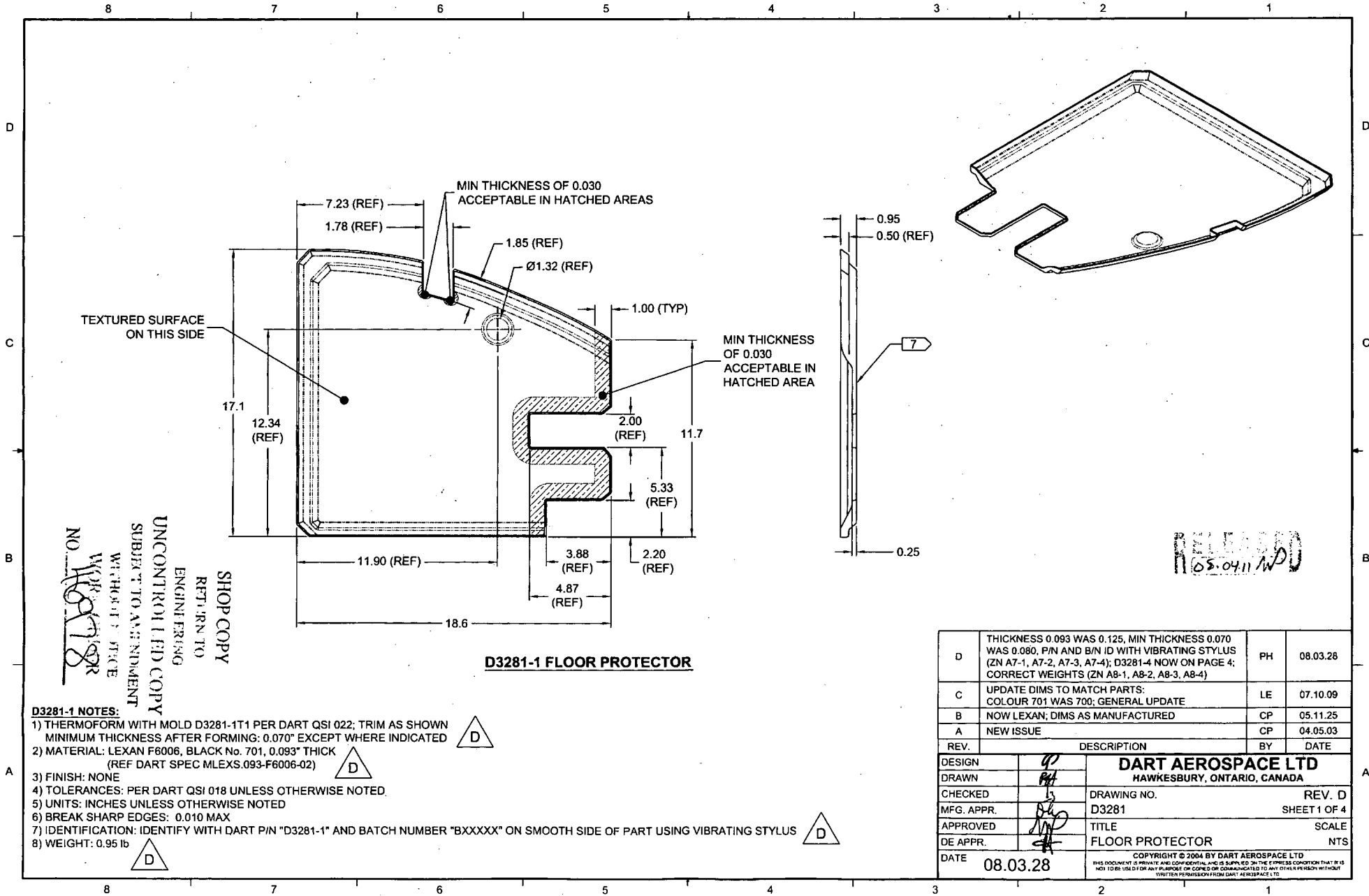
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.75				
17.1	+/-0.100	17.1				
14.3	+/-0.100	14.3				
0.95	+/-0.030	.976				
N/A -0.25	+/-0.030					
N/A 3.1	+/-0.100					
0.050	Min	.058				
0.070	Min	.075				

<b>Measured by:</b> BB	<b>Date:</b> 09/04/22
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<b>Audited by:</b> Z	<b>Date:</b> 09.04.22
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<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A
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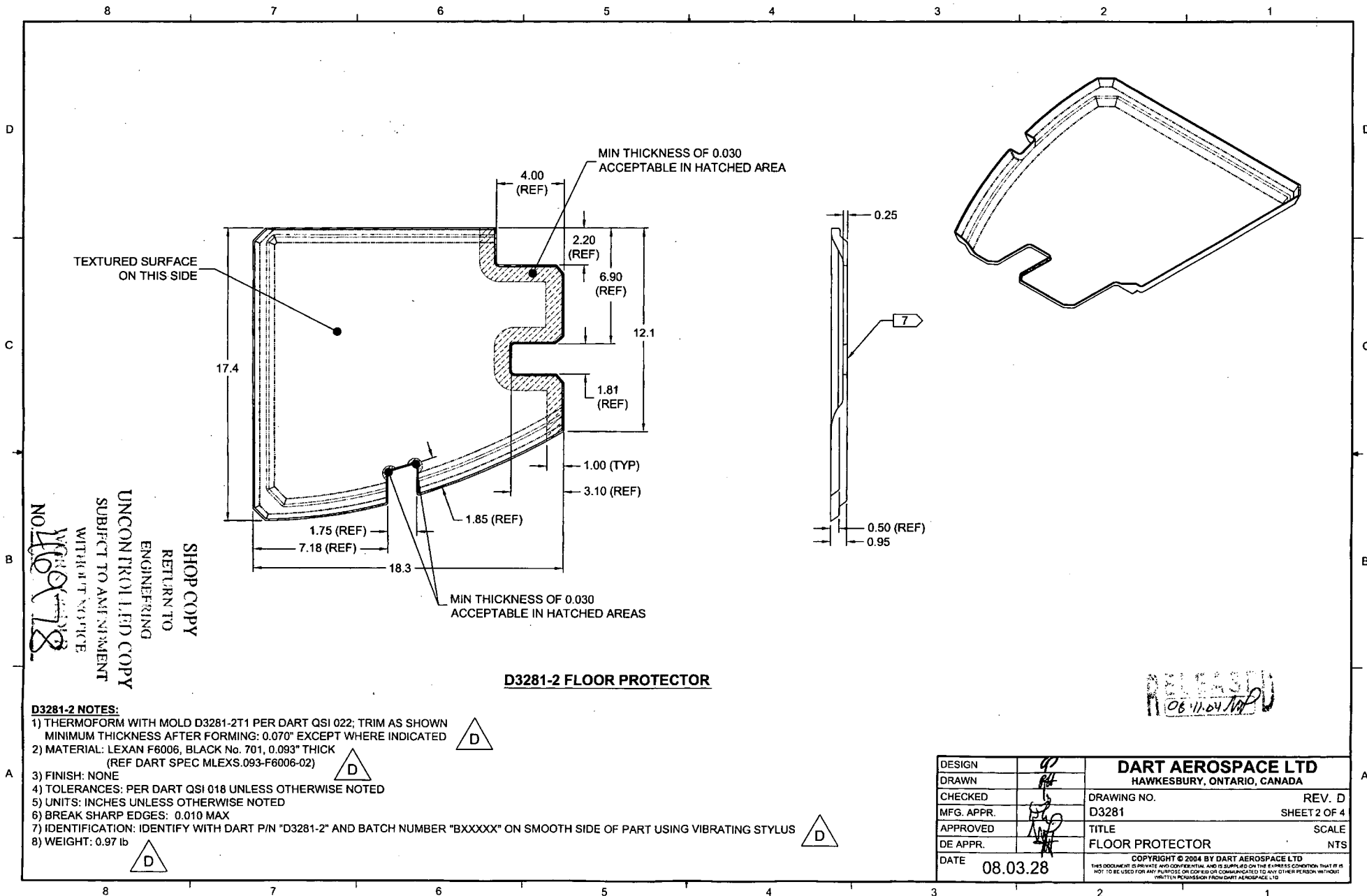
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	

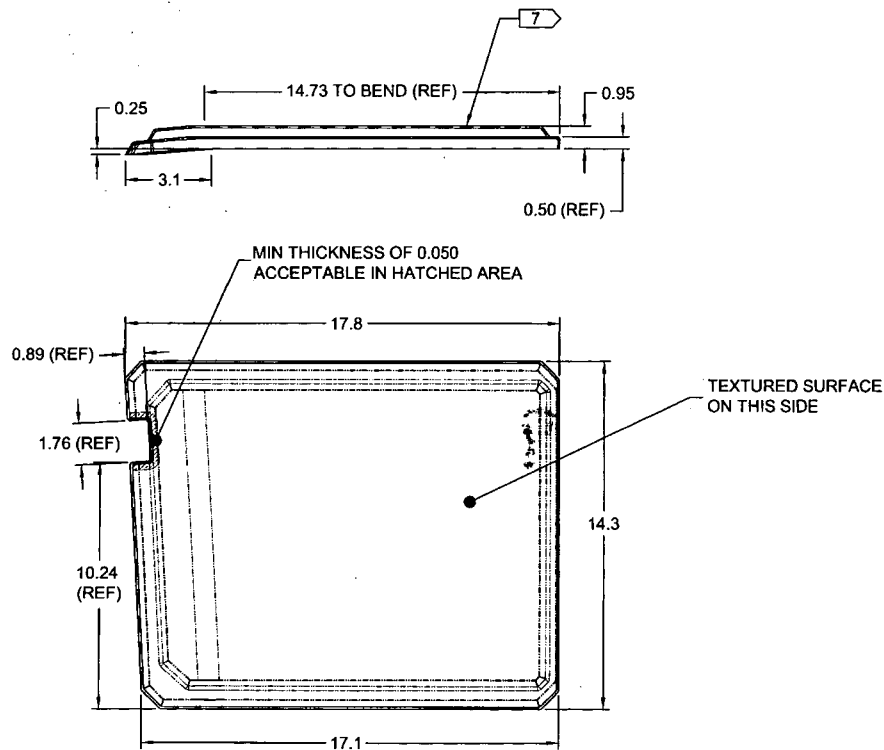


D3281-1 FLOOR PROTECTOR

- D3281-1 NOTES:**
- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
  - MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
  - 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK (REF DART SPEC MLEXS.093-F6006-02)
  - 3) FINISH: NONE
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: 0.010 MAX
  - 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
  - 8) WEIGHT: 0.95 lb

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	LS		
MFG. APPR.	PL		
APPROVED	WPD		
DE APPR.	WPD		
DATE	08.03.28	DRAWING NO.	REV. D
		D3281	SHEET 1 OF 4
		TITLE	SCALE
		FLOOR PROTECTOR	NTS
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**D3281-3 FLOOR PROTECTOR**

**D3281-3 NOTES:**

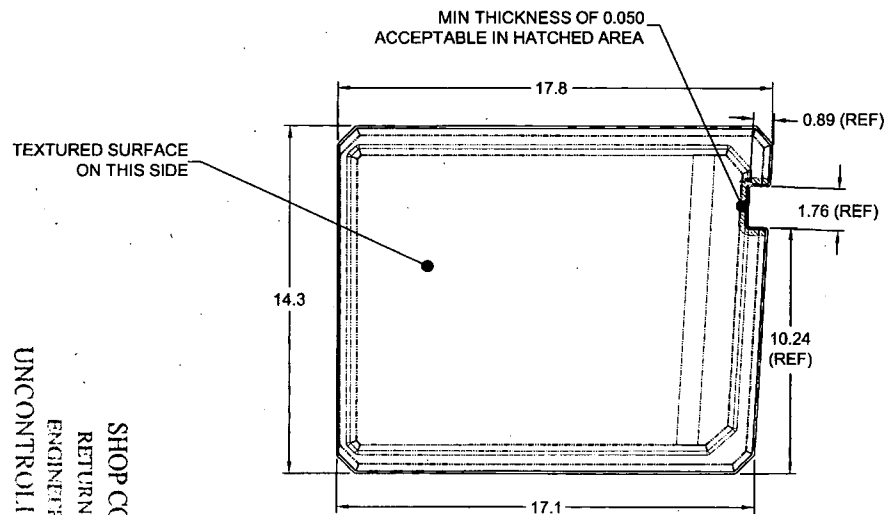
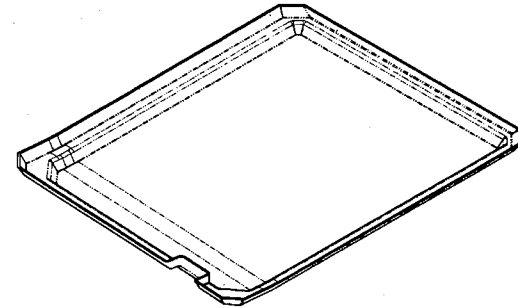
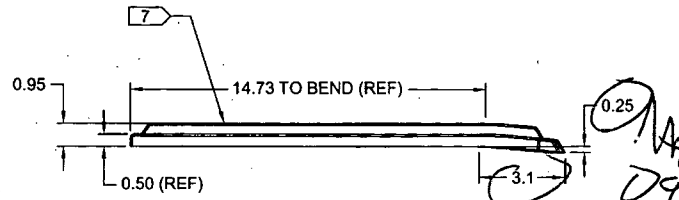
- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

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HAWKESBURY, ONTARIO, CANADA

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D3281	REV. D SHEET 3 OF 4
DRAWN	94			
CHECKED	94			
MFG. APPR.	94			
APPROVED	94			
DE APPR.	94	FLOOR PROTECTOR	SCALE NTS	NTS
DATE	08.03.28			
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**D3281-4 FLOOR PROTECTOR**

**D3281-4 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN		DRAWING NO.	REV. D
DRAWN		D3281	SHEET 4 OF 4
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DATE	08.03.28		